

Date: Wednesday, 30/04/2008 6:56:21 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR ASSEMBLY
Job Number :	38894		
Estimate Number :	10713		
P.O. Number :		Part Number :	D3213041
This Issue :	30/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3213 REV A
First Issue :	///	Project Number :	N/A
Previous Run :	38820	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	05/05/2008
Written By :		Qty:	2 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 05-11-17 17:27		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
2 D3161-3	Hinge	

~~B38834~~
 B38334x4 ✓

ml

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D3213-1	Door	B38834

x2

✓

ml

3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D3213-3	Door	B38836

x2

✓

ml

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
24 MS20470AD4-4	Rivet	M106552

✓

ml

08/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/04/2008 6:56:21 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 38894

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

ml 08/05/01 *x2*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/01 *(x2)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:00am

5 08-05-01 *(x2)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h 08/05/01 *(2X)*

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

B37068

✓ ml

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle

B37069

✓ ml 08/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/04/2008 6:56:21 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 38894

Part Number: D3213041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2462	Seal
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Comment: Qty.: 2.4000 f(s)/Unit Total : 4.8000 f(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2462	Seal	B37747

✓ ml

12.0	D27281	Dart Logo Label - small
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D2728-1	Decal	B24215

✓ ml

13.0	AN960JD6	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	AN960JD6	Washer	M6085

✓ ml

14.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	MS20470AD4-6	Rivet	107082

✓ ml

15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

x2
ml 08/05/01

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ml 08/05/01 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pe 8/5/0 1 (2)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05

Job Completion



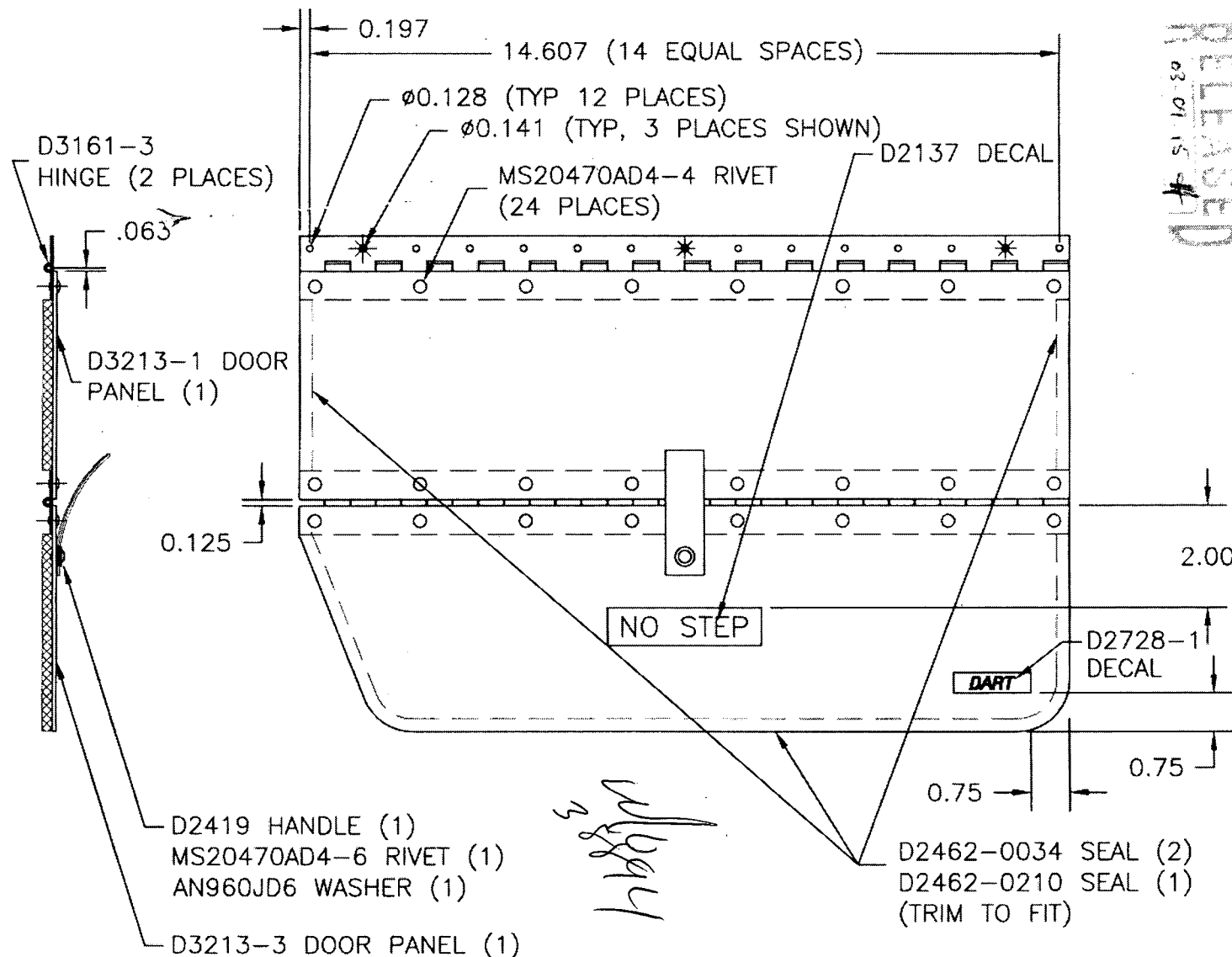
MF 08-05-01

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE 03.09.03	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	SCALE 1:3
	NEW ISSUE	

RELEASED
03-01-15



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

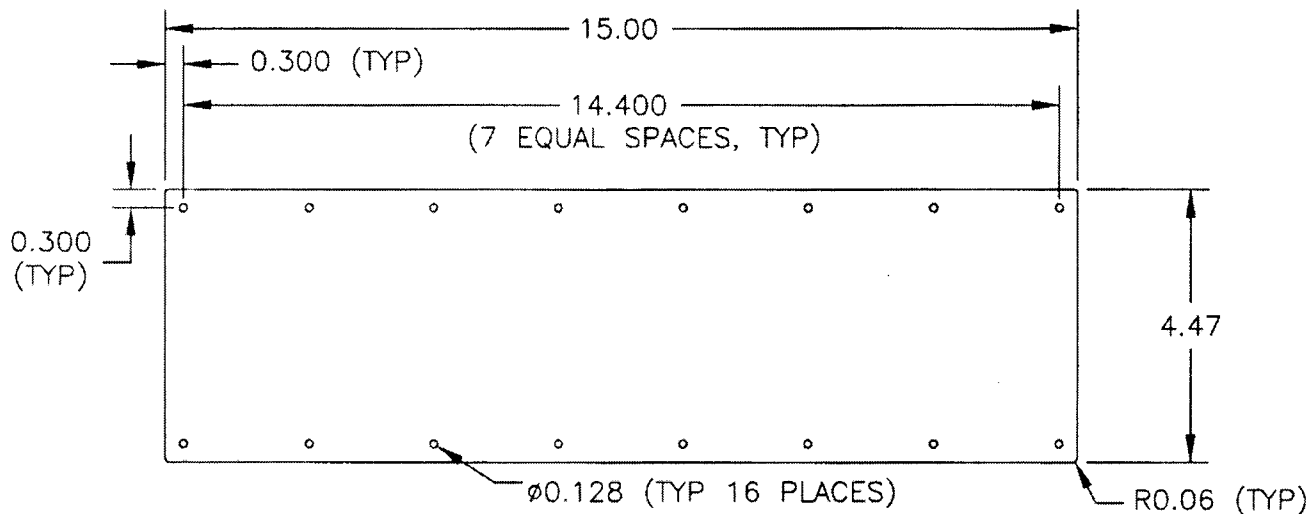
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

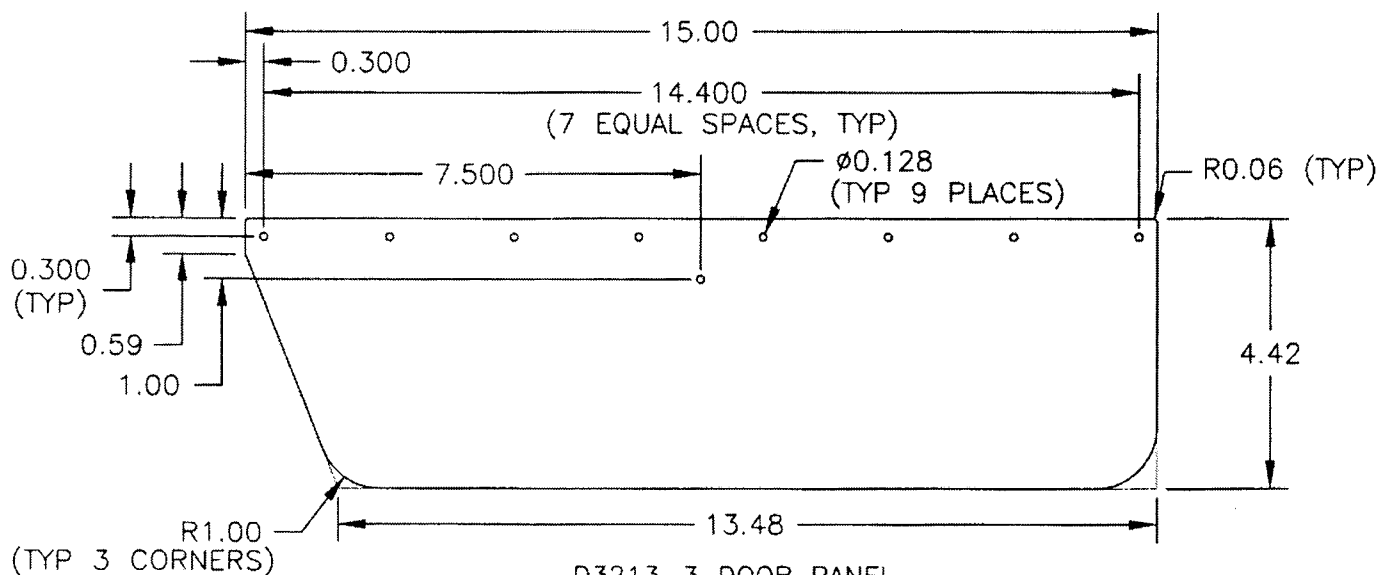
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03 09 15

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